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D3391-023

Job Sheet 168619-A



Part No: D3391-023

Job Qty: 1 ea

Part Name: Mid Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/20/17

Job Tracking No:

Due Date: 11/30/17

Created By: Linda Lacelle

Type: SOLD

Description:

Customer: Abu Dhabi Aviation (CABUD01)

PO Box 2723, Abu Dhabi International Airport Abu Dhabi, , 2723 United Arab Emirates ph:971 2 575 8000
fx:971 2 575 7775.

Note: DWG REV J SHEET 7 IPP A 05.10.20 New Issue KJ/EC IPP B IPP C 07.03.20 rev F dwg EC IPP D 07.03.28 re-format EC IPP E 07.10.31 ecn 1053P EC IPP Rev:F ECN 1056 07-11-13 DD verified by: EC IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC IPP Rev:I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP Rev:J add in seq 140 expire date &b# sikaflex DD 10.02.17 verified by:EC

Ship Via:

Bill of Materials

Job Routing

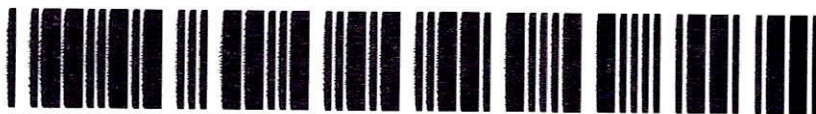
Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Run hrs Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/29/17	11/29/17	0.00 0.00	Start Up Skid tubes		
100	Skid tubes	1 pcs	11/29/17	11/29/17	0.88 2.11	Skid tubes		AP 2017-12-14
110	QC	1 pcs	11/29/17	11/29/17	0.00 0.00	QC5		LA 17-12-15
120	HandFinish	1 pcs	11/29/17	11/29/17	0.00 0.38	HandFinish1		AP 17-12-15
130	QC	1 pcs	11/29/17	11/29/17	0.00 0.00	QC7		AP 17-12-15
140	Skid tubes	1 pcs	11/29/17	11/29/17	0.00 2.11	Skid tubes		AP 2017-12-18
150	QC	1 pcs	11/29/17	11/29/17	0.00 0.00	QC5		AP 17-12-21
160	Skid tubes	1 pcs	11/29/17	11/29/17	0.00 2.11	Skid tubes		AP 17-12-21
170	QC	1 pcs	11/29/17	11/29/17	0.00 0.00	QC10		AP 17-12-21
180	QC	1 pcs	11/29/17	11/29/17	0.00 0.00	QC5		AP 17-12-21
185	HandFinish	1 pcs	11/29/17	11/29/17	0.00 0.38	HandFinish2		AP 17-12-21
191	Spray Paint	1 pcs	11/29/17	11/29/17	0.00 0.91	Spray Paint		AP 17-12-21
200	QC	1 pcs	11/29/17	11/29/17	0.00 0.00	QC14		AP 17-12-21
230	HandFinish	1 pcs	11/30/17	11/30/17	0.00 0.38	HandFinish4		AP 17-12-21
240	QC	1 pcs	11/30/17	11/30/17	0.00 0.00	QC5		AP 17-12-21
250	Packaging	1 pcs	11/30/17	11/30/17	0.00 0.00	Packaging3		AP 17-12-21
260	QC21-SA	1 Ea	11/30/17	11/30/17	0.00 0.00	QC21		AP 17-12-21

Part Op 100 - 1-Cut tube to finish length as per Dwg D3391 2-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1
Descriptions: fwd saddle hole on one side only as per Dwg D3391 3-Open aft saddles and GHW holes to Ø0.4375" except for fwd saddle
holes 4-Remove .030" from Fwd indexing Ridge as per Dwg D3391 5-Remove indexing ridge on Fwd & Aft end of
skid tube as per Dwg D3391 6-Deburr, scibe batch # on aft end. 7- Locate D3391-021 in D3391-023 at 9.00" (see view
F-F) 8- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149
locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer
drilled pilot holes in D3391-023/-021 using drill press. ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to
0.500" as per ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". D3391-021
BATCH: S017271 9- Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.375" holes with paint marker,
DO NOT DRILL HOLES #3-19-20 FROM FWD END OF JIG Locating from two fwd wearplate holes in D3391-023
drill remaining 6 wearplte holes in D3391-021 using DT8937 10- Open wearplate holes of D3391-023 assembly detail
section G-G to Ø0.375" (10 holes) as per Dwg D3391 Open wearplate holes of D3391-023 assembly detail section H-H to

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AEROSPACE
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Mid Tube Assembly

PART NO: D3391-023

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 12/14/17

Job No: 168619-A

Ø0.297" (20 holes) as per Dwg D3391 Deburr and blow out all chips from inside tube, scribe

140 - 1-Open float bag holes as per dwg 2-C'sink float bag holes as per dwg 3- Prepare tube for welding 4-Bond web in place as per Dwg D3391 & QSI 015. Adhere for 12 hours) A/R Sikaflex exp: 2018-04-21 batch#: M138654

NOTE: ENSURE WEB IS INSERTED IN AFT END OF TUBE

160 - 1-Weld crossbolt spacer as per dwg D3391 & QSI 004 2-grind weld flush

185 - Re-alodine

191 - PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT: _____

230 - 1-Install Inserts as per Dwg

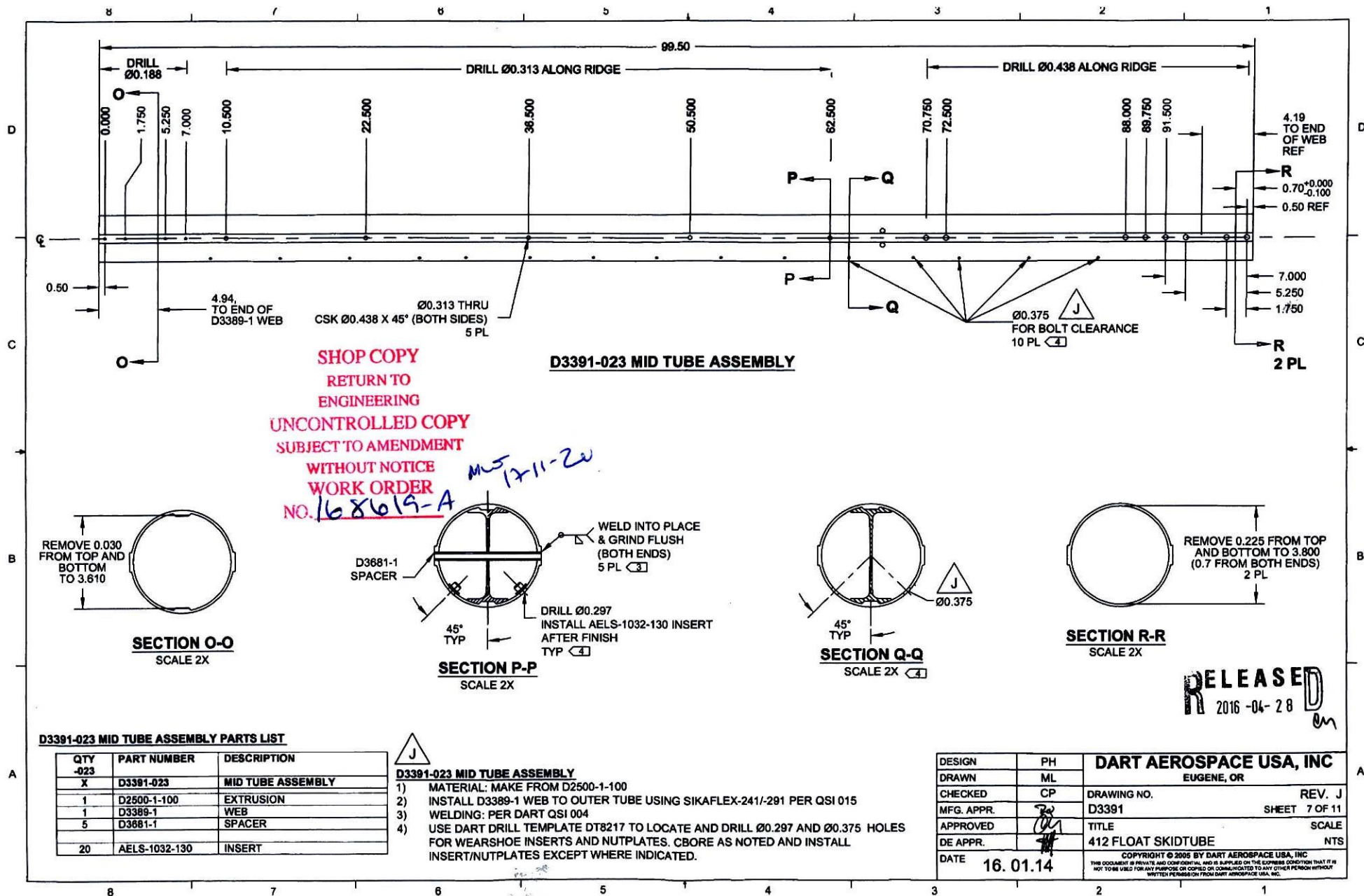
Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2500-1-100 <u>163253</u>	1	92	0	0
140-Skidtubes	D3389-1 <u>3018928</u>	1	8	0	0
160-Skidtubes	D3681-1 <u>3019147</u>	5	111	0	0
230-HandFinish	ALS4-1032-130 <u>5007274</u>	20	12,374	0	0
	D3591-1 <u>5019103</u>	2	85	0	0

Part Specifications

Specifications could not be found.

Plex 11/20/17 10:15 AM dart.lacelle.linda



RELEASED
2016-04-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____									